

Date: Thursday, 2/9/2006 1:54:19 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |  |
|-----------------------|---------------------------------------|------------------|--|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : MECHANICAL GROUND HANDLING WHEEL KIT |
| Job Number            | : 25782                               |                  |  |
| Estimate Number       | : 12140                               |                  |  |
| P.O. Number           | : <i>NIA</i>                          | Part Number      | : D206731042                           |
| This Issue            | : 2/9/2006                            | S.O. No.         | : <i>NIA</i>                           |
| Prsht Rev.            | : NC                                  | Drawing Number   | : IIN-D206-731 <i>pg 4,6</i>           |
| First Issue           | : <i>NIA</i>                          | Project Number   | : N/A                                  |
| Previous Run          | : 25781                               | Drawing Revision | : A                                    |
|                       | Type : LARGE FAB ASSY                 | Material         | : <i>NIA</i>                           |
| Written By            | :                                     | Due Date         | : 3/15/2006                            |
| Checked & Approved By | :                                     | Qty:             | 1 Um: Each                             |
| Comment               | : est rev. A 01.02.01 new issue EC    |                  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |        |
|-----|--------|--------|
| 1.0 | D33355 | spring |
|-----|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description | batch         |
|-----|-------------|-------------|---------------|
| 1   | D3335-5     | spring      | <i>B25909</i> |

*Ppl 06-08-24*

|     |          |                  |
|-----|----------|------------------|
| 2.0 | D3353041 | LUG ARM WELDMENT |
|-----|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description      | batch         |
|-----|-------------|------------------|---------------|
| 1   | D3353-041   | LUG ARM WELDMENT | <i>B25802</i> |

*Ppl 06-08-24*

|     |          |                     |
|-----|----------|---------------------|
| 3.0 | D3354042 | MIRROR ARM WELDMENT |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description       | batch         |
|-----|-------------|-------------------|---------------|
| 1   | D3354-042   | Left Arm Weldment | <i>B25911</i> |

*Ppl 06-08-24*

|     |        |     |
|-----|--------|-----|
| 4.0 | D33561 | pin |
|-----|--------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description | batch         |
|-----|-------------|-------------|---------------|
| 1   | D3356-1     | pin         | <i>B25912</i> |

*Ppl 06-08-24*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:54:20 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25782

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

| qty | Part Number | Description | batch |
|-----|-------------|-------------|-------|
| 2   | D3397-041   | Wheel ass'y |       |

*B25804*

*CPL 06-09-06*

6.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description    | batch |
|-----|-------------|----------------|-------|
| 1   | 113-800     | GREASE FITTING |       |

*M101058*

*CPL 06-08-24*

7.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

| qty | Part Number | Description | batch |
|-----|-------------|-------------|-------|
| 2   | 656-051     | flat washer |       |

*M17413*

*CPL 06-08-24*

8.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description | batch |
|-----|-------------|-------------|-------|
| 1   | 663-079     | Lock washer |       |

*M16362*

*CPL 06-08-24*

9.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

| qty | Part Number | Description | batch |
|-----|-------------|-------------|-------|
| 1   | AN5-23A     | Bolt        |       |

*M19278*

*CPL 06-08-24*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:54:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25782

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty Part Number Description  
1 AN960JD516L Washer

batch

*M101369*

*CPL 06-08-24*

11.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty Part Number Description  
2 SNF-34 *CP21* 1/8" Cotter Pin 2" long

batch

*M16301*

*CPL 06-08-24*

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty Part Number Description  
1 MS21042L5 Nut

batch

*M101648*

*CPL 06-08-24*

13.0

SNF34

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

pick:

qty Part Number Description  
*X* 2 SNF-34 ~~1/8" Cotter Pin 2" long~~

batch

*M16354*

*Slotted Nut*

*CPL 06-08-24*

14.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

qty Part Number Description  
1 TP-2 Spring pin

batch

*M16588*

*CPL 06-08-24*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/09/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:54:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MECHANICAL GROUND HANDLING WHEEL KIT

Job Number: 25782

Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| qty | Part Number | Description |
|-----|-------------|-------------|
| 1   | TP-134      | Spring pin  |

batch

*M16362*

*Cpl 06-08-24*

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

*Cpl 06-09-06*

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-09-07 (1)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*N/A*

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/09/15 (1)*

Job Completion



*U 06-09-15*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



PRELIMINARY ISSUE

## 4.0 PARTS LIST

| QTY<br>-011 | QTY<br>-041 | QTY<br>-042 | Part Number  | Description                           |
|-------------|-------------|-------------|--------------|---------------------------------------|
| X           |             |             | D206-731-011 | MECHANICAL GROUND HANDLING WHEEL KIT  |
| 1           | X           |             | D206-731-041 | MECHANICAL GROUND HANDLING WHEEL (LH) |
| 1           |             | X           | D206-731-042 | MECHANICAL GROUND HANDLING WHEEL (RH) |
|             | 1           | 1           | D3335-5      | * SPRING                              |
|             |             | 1           | D3353-041    | * LUG ARM WELDMENT                    |
|             | 1           |             | D3353-042    | * LUG ARM WELDMENT                    |
|             | 1           |             | D3354-041    | * LEFT ARM WELDMENT                   |
|             |             | 1           | D3354-042    | * MIRROR ARM WELDMENT                 |
| 1           |             |             | D3355-041    | * HANDLE ASSEMBLY                     |
|             | 1           | 1           | D3356-1      | * PIN                                 |
|             | 2           | 2           | D3397-041    | * WHEEL ASSEMBLY                      |
| 1           |             |             | D3381-1      | ** LABEL                              |
|             | 1           | 1           | 113-800      | * GREASE FITTING                      |
|             | 2           | 2           | 656-051      | * FLAT WASHER                         |
|             | 1           | 1           | 663-079      | * LOCK WASHER                         |
|             | 1           | 1           | AN5-23A      | * BOLT                                |
|             | 1           | 1           | AN960JD516   | * WASHER                              |
|             | 2           | 2           | CP-21        | * COTTER PIN                          |
|             | 1           | 1           | MS21042L5    | * NUT                                 |
|             | 2           | 2           | SNF-34       | * SLOTTED NUT                         |
|             | 1           | 1           | TP-2         | * SLOTTED SPRING TENSION PIN          |
|             | 1           | 1           | TP-134       | * SLOTTED SPRING TENSION PIN          |

\* shown for reference only, part is included in D206-731-041/ -042 assemblies above

\*\* shown for reference only, part is included in D3355-041 assembly above

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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 25782

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Revision: A

Date: 05.01.26

PRELIMINARY ISSUE

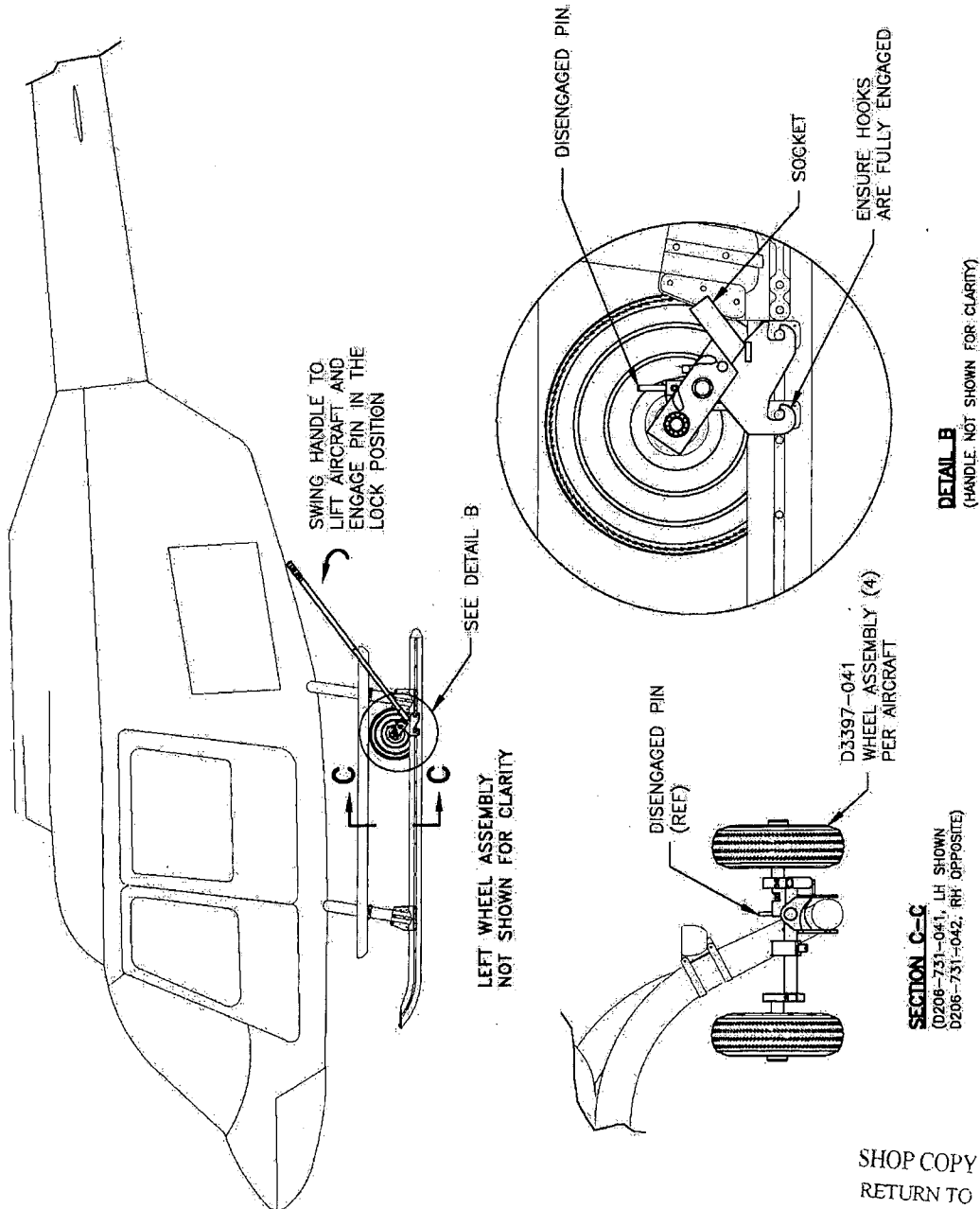


Figure 2 - D206-731-041 Mechanical Ground Handling Wheel Installation  
(Left Side Shown, Right Side Opposite)

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